

Date Thursday, 16/08/2007 10:31:41 AM  
User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WASHER
Job Number	: 34013		
Estimate Number	: 11314		
P.C. Number	: <i>NA</i>	Part Number	: D34571
This Issue	: 16/08/2007 S.O. No. : <i>NA</i>	Drawing Number	: D3457 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 32409	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 05/09/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. 05.10.03 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0218 f(s)/Unit Total: 0.4368 f(s)

Delrin Round Bar 1"

Material: Delrin Round Bar Ø1.000

(M-DELRIN-R1.000)

Batch: *M104346*

Identify for D3457-1

*.53'**20 07/09/13*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA589 Rev: *A* & Dwg D3457 Rev: *A**20 07/09/13 (23)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment:

Machine as per Folio FA589 Rev: *A* & Dwg D3457 Rev: *A**J.L 07/09/19 (23)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 07/09/19*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*[Signature] 07-04-20 (23)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 01/09/00  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:31:41 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 34013

Part Number: D34571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

J.L. 07/09/19

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5+95

*[Signature]* 07/09/20 (23)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(23)

07/09/20

Job Completion



U 07-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

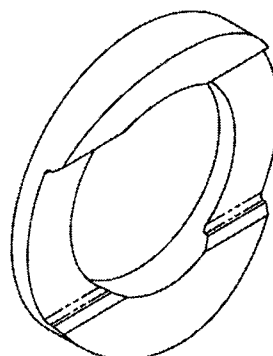
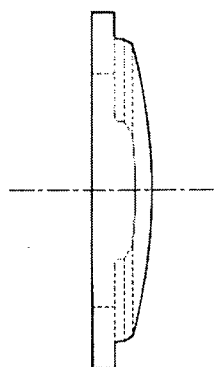
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

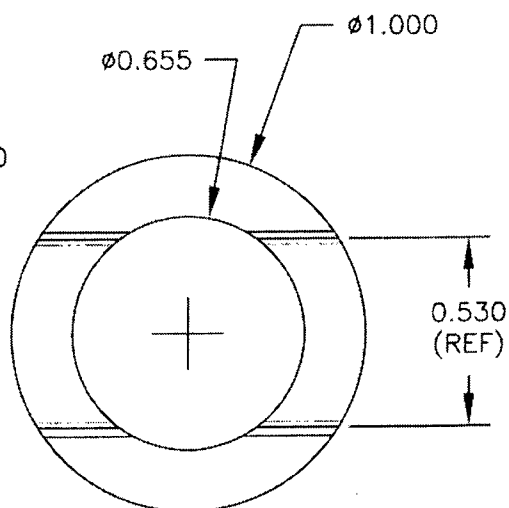
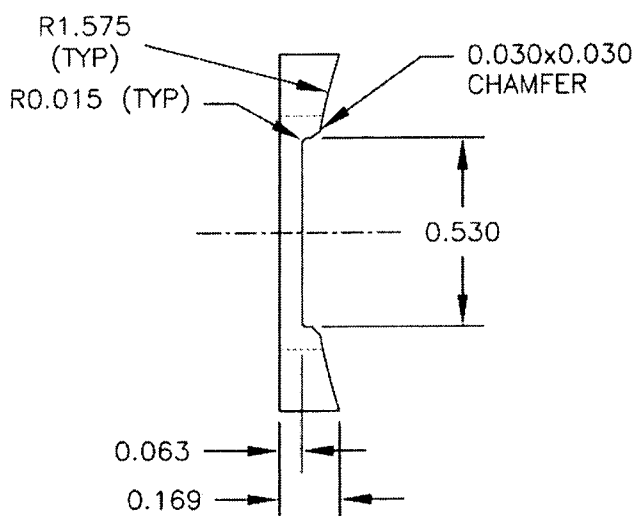


DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06			TITLE WASHER SCALE 2:1		
A	05.09.06		NEW ISSUE		

05.09.06 #



**ISOMETRIC DETAIL**



w/o 34013

**D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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PROSPACE LTD

Work Order: 34013

Washer

Part Number: B3457-1

Draw: B3457 Rev: A

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Part No	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/- .010	1.002	✓			
.655	+/- .010	.655	✓			
.169	+/- .010	.171	✓			
.063	+/- .010	.065	✓			
.530	+/- .010	.527	✓			
1.1575	+/- .000	1.1575	✓			
ROU15	+/- .000	.0015	✓			
.030	+/- .010	.040	✓			

Date: 6/29/13 By: J.R.	Audited by: J.B. Date: 07/03/13	Prototype Approval Date:	Revised Date:
Change New Issue			